

Date: Tuesday, 13/01/2009 4:07:49 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LATCH ASSEMBLY
Job Number :	44741		
Estimate Number :	13370		
P.O. Number :		Part Number :	D3589041
This Issue :	13/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3589 REV B PRELIM
First Issue :	1/1	Project Number :	N/A
Previous Run :	40366	Drawing Revision :	PRELIM
Written By :		Material :	
Checked & Approved By :	<u>UMF 09-1-13</u>	Due Date :	20/01/2009
Comment :	Est Rev:A new issue 08-06-05 DD verified by:ec		

Additional Product

PRELIMINARY ISSUE

Job Number:



09-01-13
 POL ECU #09-5028

Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D35891	ARM
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM

batch: B44734

09/01/16

2.0	D35893	ARM GUIDE
-----	--------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

ARM GUIDE

batch: B44733

09/01/16

3.0	D35897	AFT GUIDE PLATE
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

AFT GUIDE PLATE

batch: B44735

09/01/16

4.0	D35899	FWD GUIDE PLATE
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD GUIDE PLATE

batch: B44819

09/01/16

5.0	D358911	FWD GUIDE PLATE
-----	---------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD GUIDE PLATE

batch: B44736

09/01/16

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 44741

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D358913

LUG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG

batch: B44737

09/01/16

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004

304 Stainless Steel Rod Batch: M107051

09/01/16

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-01-15

(x1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

09.01.16

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

IN
PR

11.0

AN960JD4

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M11735

09/01/16

12.0

D358915

LINK



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LINK

batch: ~~44738~~ B44738

09/01/16

09/01/16

Date: Tuesday, 13/01/2009 4:07:49 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 44741

Part Number: D3589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS203921C7

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch:

M108521

JS 09/01/16 (K)

14.0

MS246651010 → NO STOCK

COTTER PIN



ACCEPTABLE TO
USE MS246651013 AND CUT
TO LENGTH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

COTTER PIN

batch:

Batch: M19096

09.01.16

09/01/16

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg D3589

09/01/16

16.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09.01.16

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

D412761-043 B 44741

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion

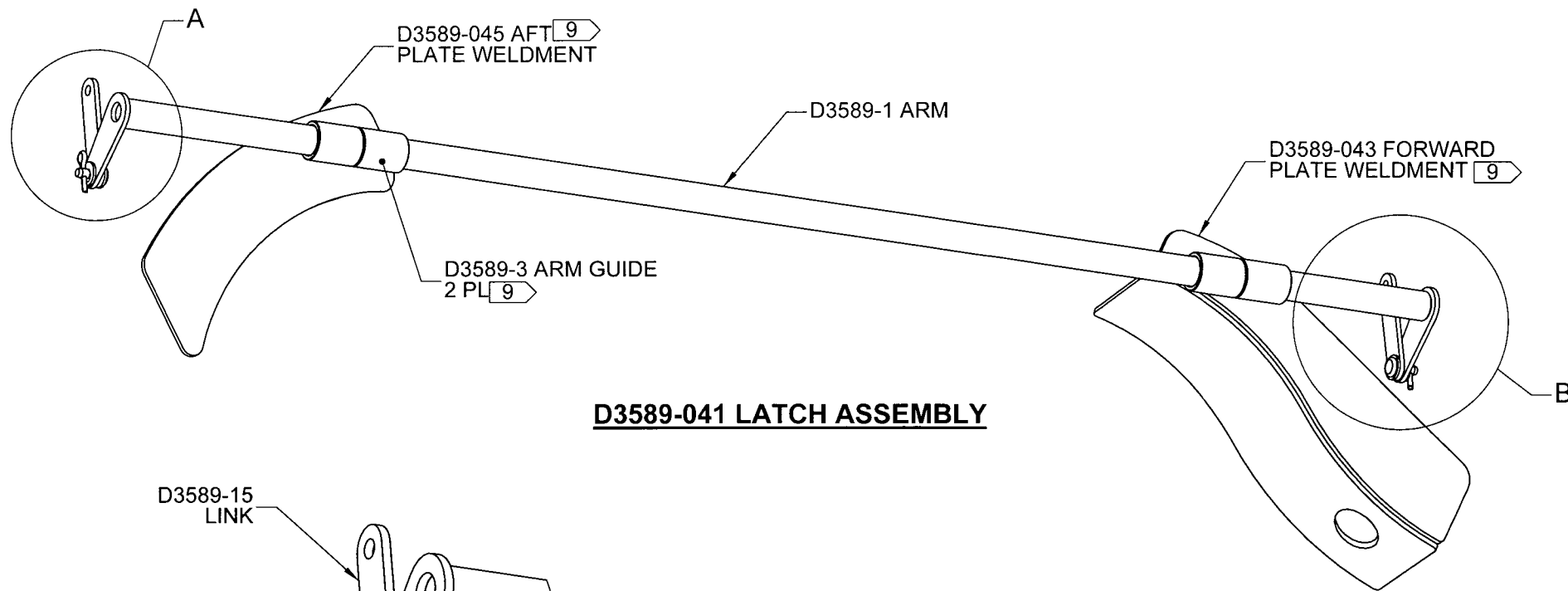


MF 09-01-16

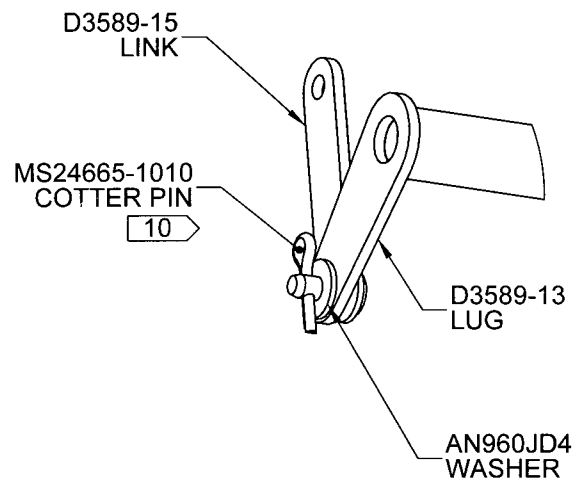
POSITIVE RECALL

EFFECTIVE 09.01.14 AUTH L

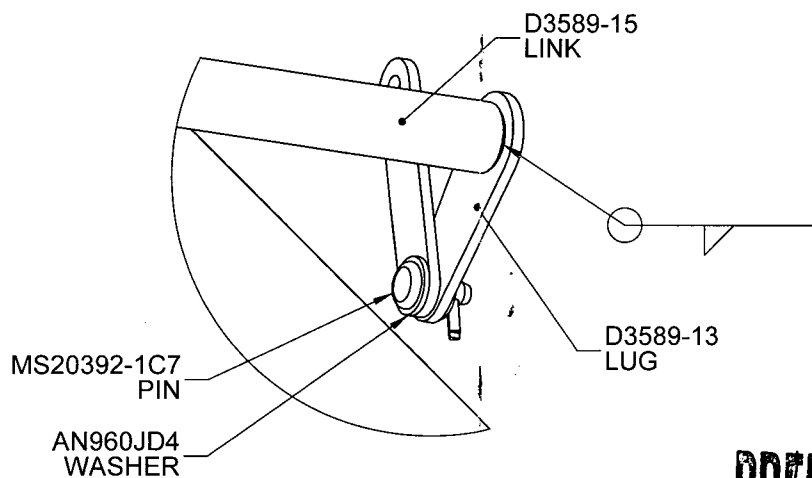
RELEASED DATE 09.02.17



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

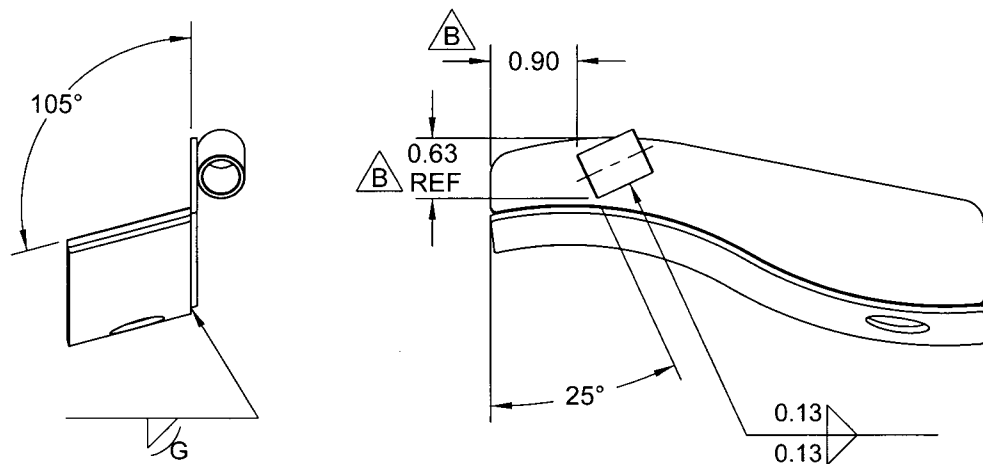
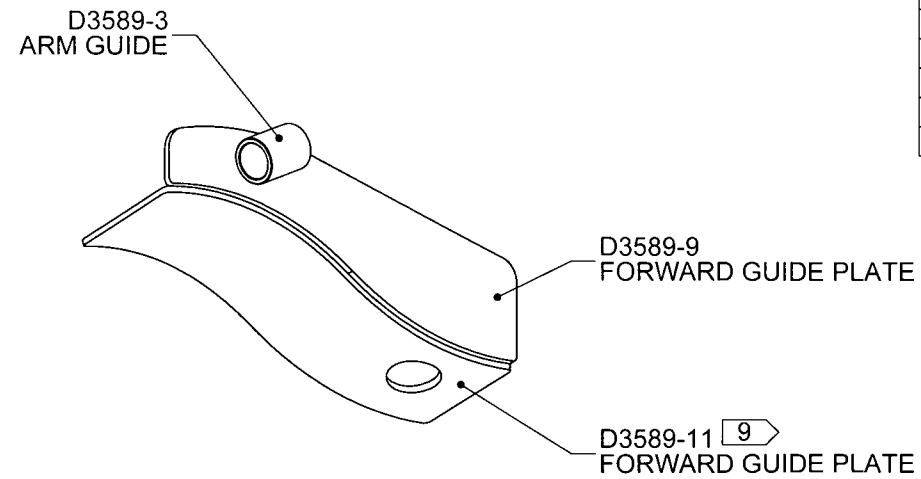
44741
PRELIMINARY ISSUE
406.01.13
Per ECN# 09-702P

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

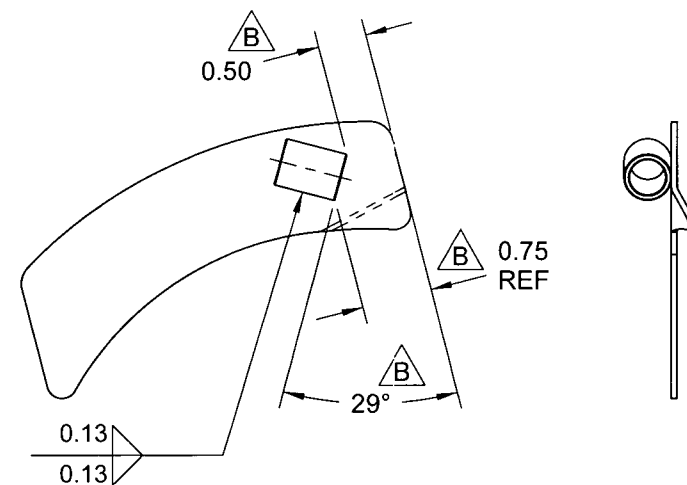
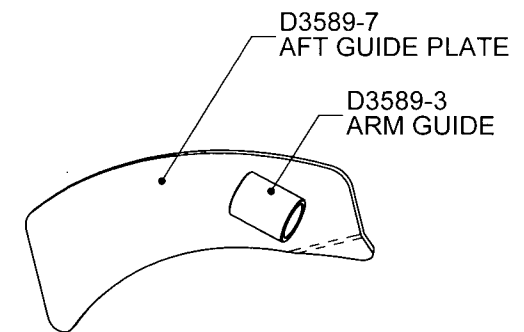
- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

PRELIMINARY ISSUE

44741
09-0413
PER ECN# 09-502P

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3589	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 8	
APPROVED	<i>[Signature]</i>	TITLE LATCH ASSEMBLY	SCALE
DE APPR.		NTS	
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

TABLE V. DASH NUMBERS AND DIMENSIONS - CORROSION RESISTANT STEEL

L LENGTH	NOMINAL DIAMETER															
	1/32	3/64	1/16	5/64 ^{1/}	3/32	1/8	5/32	3/16	7/32 ^{1/}	1/4	5/16	3/8	7/16 ^{1/}	1/2	5/8	3/4 ^{1/}
	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO	DASH NO
1/4	18	82	1010													
5/16	1001		1011													
3/8	1002		1012													
7/16	1003		1013													
1/2	22	86	151	227 ^{1/}	298	366										
3/4	24	88	153	229 ^{1/}	300	368	436	508								
1	26	90	155	231 ^{1/}	302	370	437	509	576 ^{1/}	636	697					
1-1/4	27	91	157	233 ^{1/}	304	372	439	511	577 ^{1/}	637	698					
1-1/2	28	92	159	235 ^{1/}	306	374	441	513	578 ^{1/}	638	699	763	851 ^{1/}			
1-3/4	29	93	161	237 ^{1/}	308	376	443	515	579 ^{1/}	639	700	764	852 ^{1/}			
2	30	94	162	238 ^{1/}	309	377	444	516	580 ^{1/}	640	701	765	853 ^{1/}	909		
2-1/4					310	378	445	517	581 ^{1/}	641	702	766	854 ^{1/}	910		
2-1/2	31	95	163	239 ^{1/}	311	379	446	518	582 ^{1/}	642	703	767	855 ^{1/}	911		
2-3/4							447	519								
3	32	96	164	240 ^{1/}	312	380	448	520	583 ^{1/}	643	704	768	857 ^{1/}	913	953	983 ^{1/}
3-1/2							449	521	584 ^{1/}	644	705	769	858 ^{1/}	914	954	984 ^{1/}
4							450	522	585 ^{1/}	645	706	770	859 ^{1/}	915	955	985 ^{1/}
4-1/2 ^{1/}										646 ^{1/}	707 ^{1/}	771 ^{1/}	860 ^{1/}	916 ^{1/}	956 ^{1/}	986 ^{1/}
5										647	708	772	861 ^{1/}	917	957	987 ^{1/}
6										648	710	774	862 ^{1/}	918	958	988 ^{1/}

^{1/} NOT A PREFERRED SIZE. DO NOT USE FOR NEW DESIGN

REFERENCE ONLY

P.A.	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cont	OS 99		PIN, COTTER (SPLIT)	MS24665
PROCUREMENT SPECIFICATION	SUPERSEDES			PAGE
ANSI B18.8.1	BFAX3, BFA3.1, BFA3.2, AN380, AND AN381			5 OF 8

USER ACTIVITIES
ARMY - AT, ME, MI
NAVY - YDREVIEWER ACTIVITIES
ARMY - AVER
AIR FORCE - II, B2
NSA - NS
DLA - BThis military standard is approved for use by all Departments and Agencies of the Department of Defense.
Selection for all new engineering and design applications and for repetitive use shall be made from this document where applicable.

APPROVED: 16 MAR 80 REVISION: F FOR CHANGES PAGES 1, 2, 3, 4, 5, 6, 7 AND 8

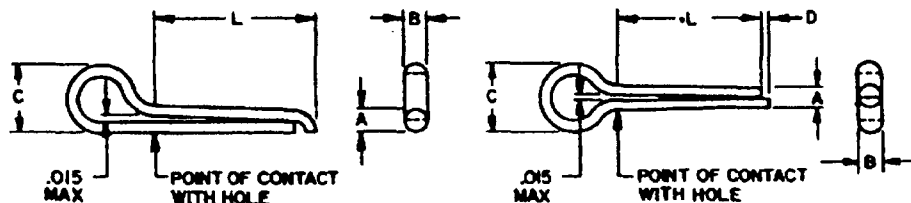
HAMMER LOCK
(SEE NOTE 2)EXTENDED PRONG SQUARE CUT
(PLAIN)
(SEE NOTE 2)

TABLE I CONFIGURATION DIMENSIONS

SIZE NOMINAL DIAMETER	A		B		C		D	HOLE SIZE RECOMMENDED
	MAX	MIN	MAX	MIN	MIN	MIN		
1/32 - .031	.052	.028	.052	.022	.06	.01		.047
3/64 - .047	.048	.044	.048	.075	.09	.02		.062
1/16 - .062	.060	.056	.060	.044	.12	.03		.078
1/ 5/64 - .078	.076	.072	.076	.057	.16	.04		.094
3/32 - .094	.090	.086	.090	.069	.19	.04		.109
1/8 - .125	.120	.116	.120	.093	.25	.06		.141
5/32 - .156	.150	.146	.150	.116	.31	.07		.172
3/16 - .188	.176	.172	.176	.137	.38	.09		.203
1/ 7/32 - .219	.207	.202	.207	.161	.44	.10		.234
1/4 - .250	.225	.220	.225	.176	.50	.11		.266
5/16 - .312	.280	.275	.280	.220	.62	.14		.312
3/8 - .375	.335	.329	.335	.263	.75	.16		.375
1/ 7/16 - .438	.406	.400	.406	.320	.88	.20		.438
1/2 - .500	.473	.467	.473	.373	1.00	.23		.500
5/8 - .625	.598	.590	.598	.472	1.25	.30		.625
1/ 3/4 - .750	.723	.715	.723	.572	1.50	.36		.750

1/ Not a preferred size. Do not use for new design.

REFERENCE ONLY

REQUIREMENTS

- MATERIAL** CARBON, STEEL, BRASS, CORROSION RESISTANT STEEL AND NICKEL COPPER ALLOY IN ACCORDANCE WITH PROCUREMENT SPECIFICATION.
- PROTECTIVE COATING** CARBON STEEL SHALL BE CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE II, CLASS 3 OR PHOSPHATE COATED IN ACCORDANCE WITH MIL-P-16232, TYPE 2, CLASS 3 AND THE PROCUREMENT SPECIFICATION. BRASS SHALL BE BLACK CROMICAL FINISH AS SPECIFIED IN MIL-P-495 AND IN ACCORDANCE WITH THE PROCUREMENT SPECIFICATION. CORROSION RESISTANT STEEL SHALL BE CLEANED, DESCALED AND PASSIVATED IN ACCORDANCE WITH ASTM A380 AND THE PROCUREMENT SPECIFICATION.

(F) ENTIRE STANDARD REVISED

P A	AR	INTERNATIONAL INTEREST	TITLE	MILITARY STANDARD
Other Cont	OS 99		PIN, COTTER (SPLIT)	MS24665
PROCUREMENT SPECIFICATION ANSI B18.8.1	SUPERSEDES BFAX3, BFA33.1, BFA33.2, AN380, AND AN381		PAGE 1	OF 8

AMSC N/A

DD FORM 672-1 (COORDINATED)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

5315-0424

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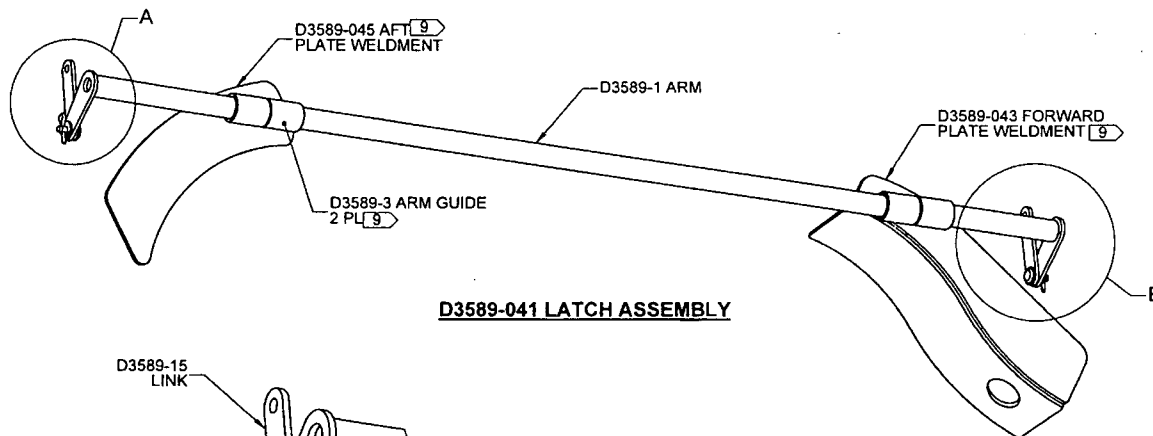
This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document when applicable.

USER ACTIVITIES
ARMY-AT, ME, M1
NAVY-YD

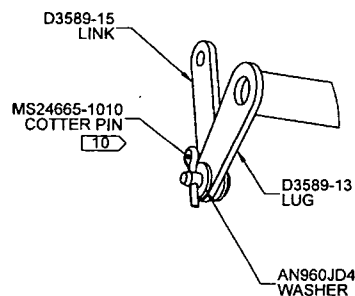
REVIEWER ACTIVITIES
ARMY-AV, ER
AIR FORCE-II, B2
NSA-NS
DLA-IS

APPROVED 16 MAR 60
REVISED 18 JUN 86

QTY.	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

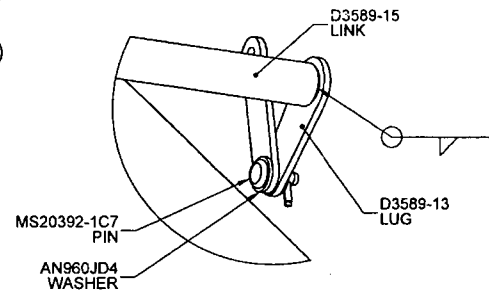


D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL

SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**

SCALE 2X
2 PL

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

1147741

RELEASED
EP 62/65/147

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

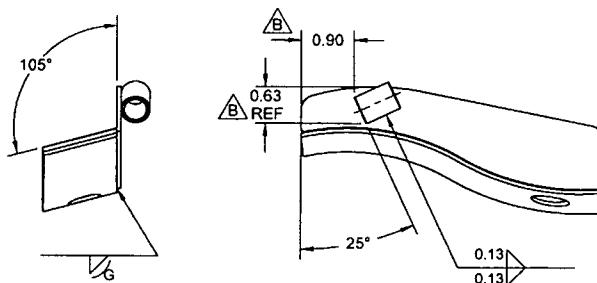
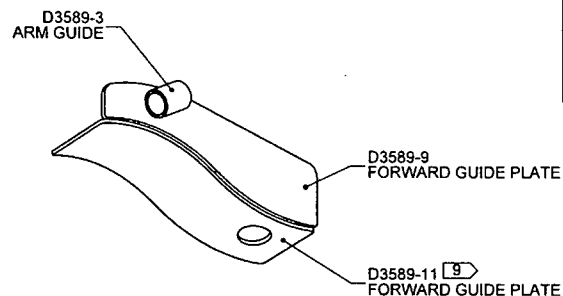
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. B
SHEET 1 OF 8

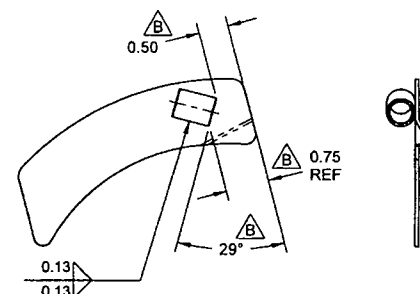
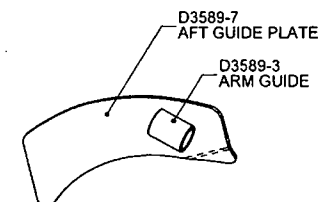
TITLE **LATCH ASSEMBLY** SCALE NTS

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QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

RELEASED
09/03/05

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 8
DE APPR.		TITLE LATCH ASSEMBLY
DATE	08.06.25	SCALE NTS
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